

Date: Friday, 02/05/2008 7:03:50 AM  
User: Linda Lacelle

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> : TUBE ASSEMBLY 25"                    |
| <b>Job Number</b> : 38978                             |  |
| <b>Estimate Number</b> : 11190                        |  |
| <b>P.O. Number</b> :                                  | <b>Part Number</b> : D3298001                              |
| <b>This Issue</b> : 02/05/2008 <b>S.O. No.</b> :      | <b>Drawing Number</b> : D3298 REV A2                       |
| <b>Prsht Rev.</b> : NC                                | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : // <b>Type</b> : SMALL /MED FAB  | <b>Drawing Revision</b> : A2                               |
| <b>Previous Run</b> : 38062                           | <b>Material</b> :  |
| <b>Written By</b> :                                   | <b>Due Date</b> : 09/05/2008 <b>Qty:</b> 5 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> :                    |  |
| <b>Comment</b> : Est A04.09.02 New issue KJ/JLM       |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                  |                          |
|-----|------------------|--------------------------|
| 1.0 | M6061T6T0375W035 | 6061-T6 Tube .375 x.035W |
|-----|------------------|--------------------------|



**Comment:** Qty.: 2.1875 f(s)/Unit Total : 10.9373 f(s)

5 x 20. "1/16"

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-001

Batch: m104921

|     |           |        |
|-----|-----------|--------|
| 2.0 | MS208196D | Sleeve |
|-----|-----------|--------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Sleeve

Pick:

|     |             |             |       |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|

|   |            |        |                  |
|---|------------|--------|------------------|
| 1 | MS20819-6D | Sleeve | <u>m107534</u> ✓ |
|---|------------|--------|------------------|

|     |         |     |
|-----|---------|-----|
| 3.0 | AN8186D | Nut |
|-----|---------|-----|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Coupling Nut

Pick:

|     |             |             |       |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|

|   |          |     |                  |
|---|----------|-----|------------------|
| 1 | AN818-6D | Nut | <u>m107756</u> ✓ |
|---|----------|-----|------------------|

08/05/12 ml

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 02/05/2008 7:03:50 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 25"

Job Number: 38978

Part Number: D3298001

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-001T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

*mul 08/05/12* <sup>75</sup>

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*208/05/12*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *SC 8/05/12 (5)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/05/14*

Job Completion



*W 08-05-13*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                               |                                |  |                        |
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| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3298                                     | REV. A<br>SHEET 1 OF 7 |
| DATE<br>04.07.06              |                                | TITLE<br>TUBE ASSEMBLIES                                 | SCALE<br>NTS           |
| A                             | 04.07.06                       | NEW ISSUE  |                        |
| A1                            | <i>[Signature]</i> 04.11.30    | CORRECT VIEW D3298-003; 16.50 WAS 15.75                  |                        |
| A2                            | <i>[Signature]</i> 05.05.06    | FOR D3298-001/-003 16.00 WAS 16.50                       |                        |

RELEASED  
04.07.06

| P/N       | TEMPLATE    | CUT LENGTH<br>OF TUBE | MS20819-6D SLEEVE | AN818-6D NUT | DESC.      | MATERIAL                                |
|-----------|-------------|-----------------------|-------------------|--------------|------------|---|
| D3298-001 | D3298-001T1 | 25.00                 | 2                 | 2            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-003 | D3298-003T1 | 27.00                 | 2                 | 2            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-005 | D3298-005T1 | 23.00                 | 2                 | 2            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-007 | D3298-007T1 | 8.00                  | 2                 | 2            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-009 | D3298-009T1 | 6.00                  | 1                 | 1            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-011 | D3298-011T1 | 8.00                  | 2                 | 2            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-013 | D3298-013T1 | 10.00                 | 2                 | 2            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-015 | D3298-015T1 | 14.00                 | 1                 | 1            | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |

*W08478*

**Notes:**

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

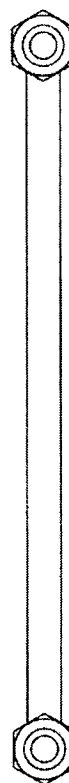
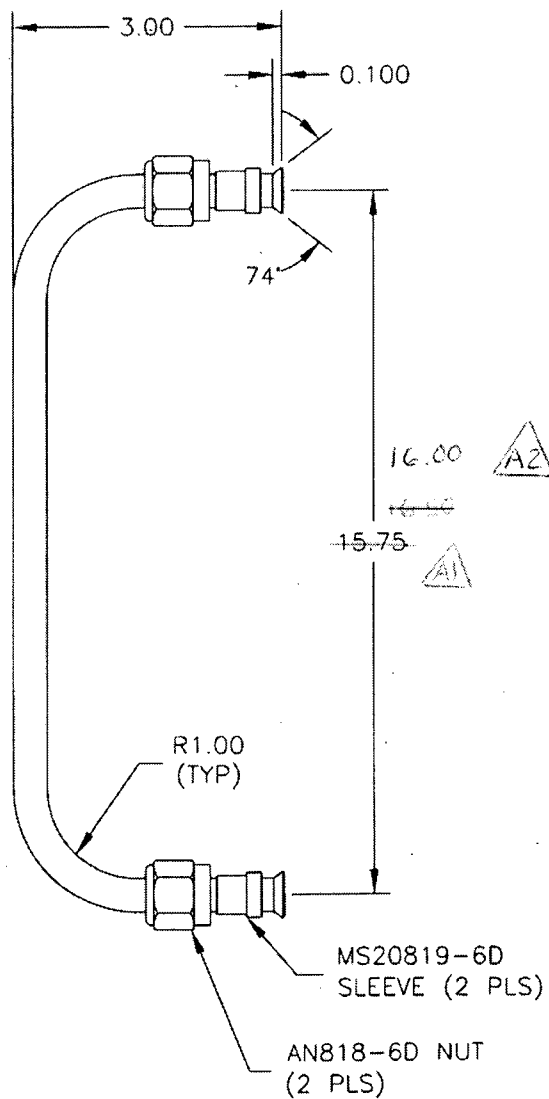
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
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**NOTE:** Date & initial all entries



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Wp 38978

D3298-001

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|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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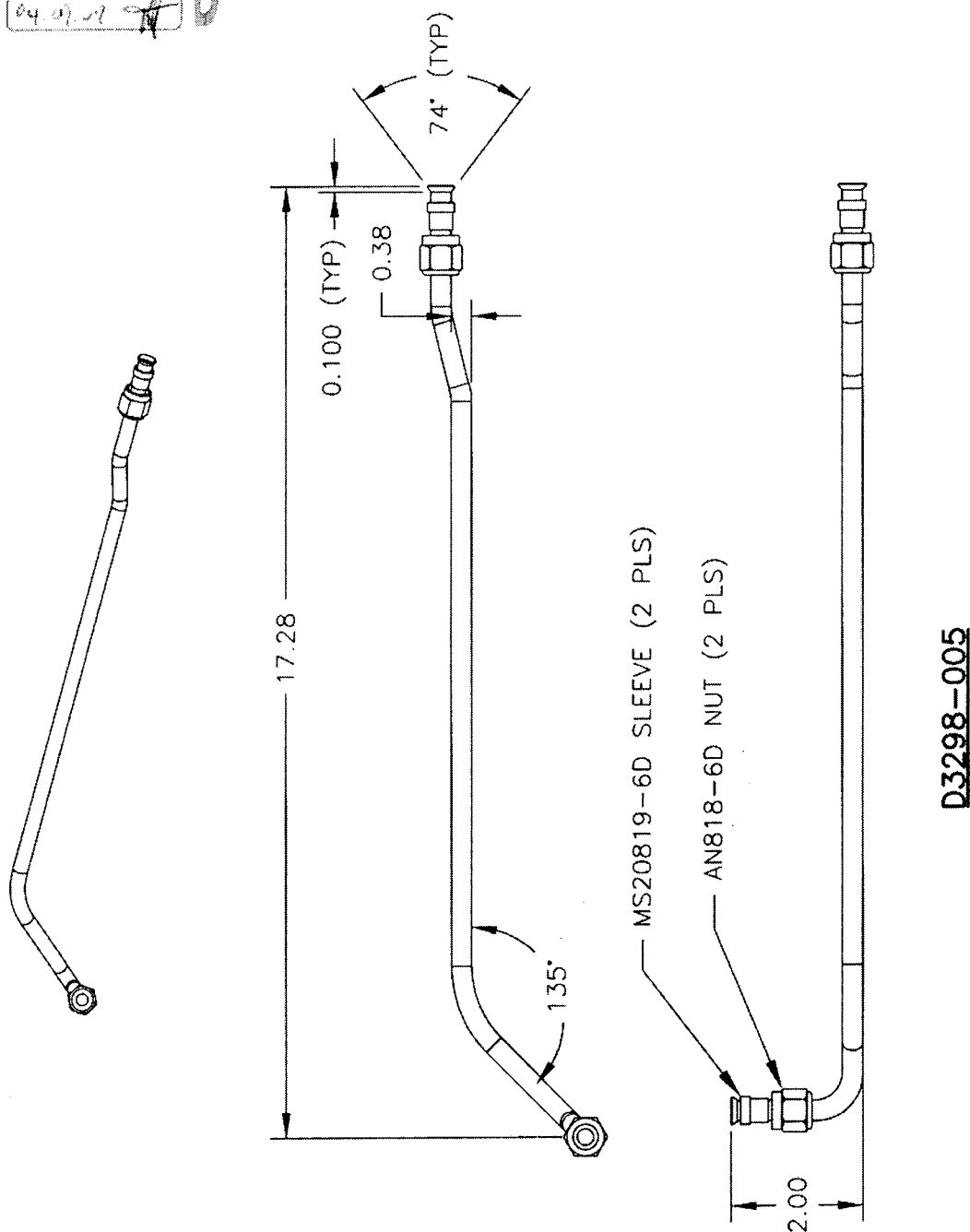
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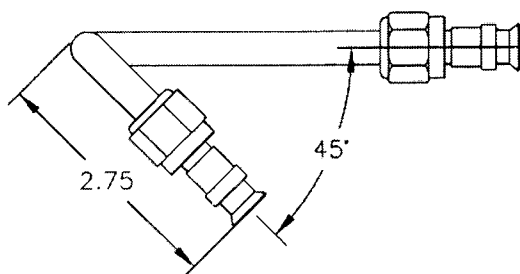
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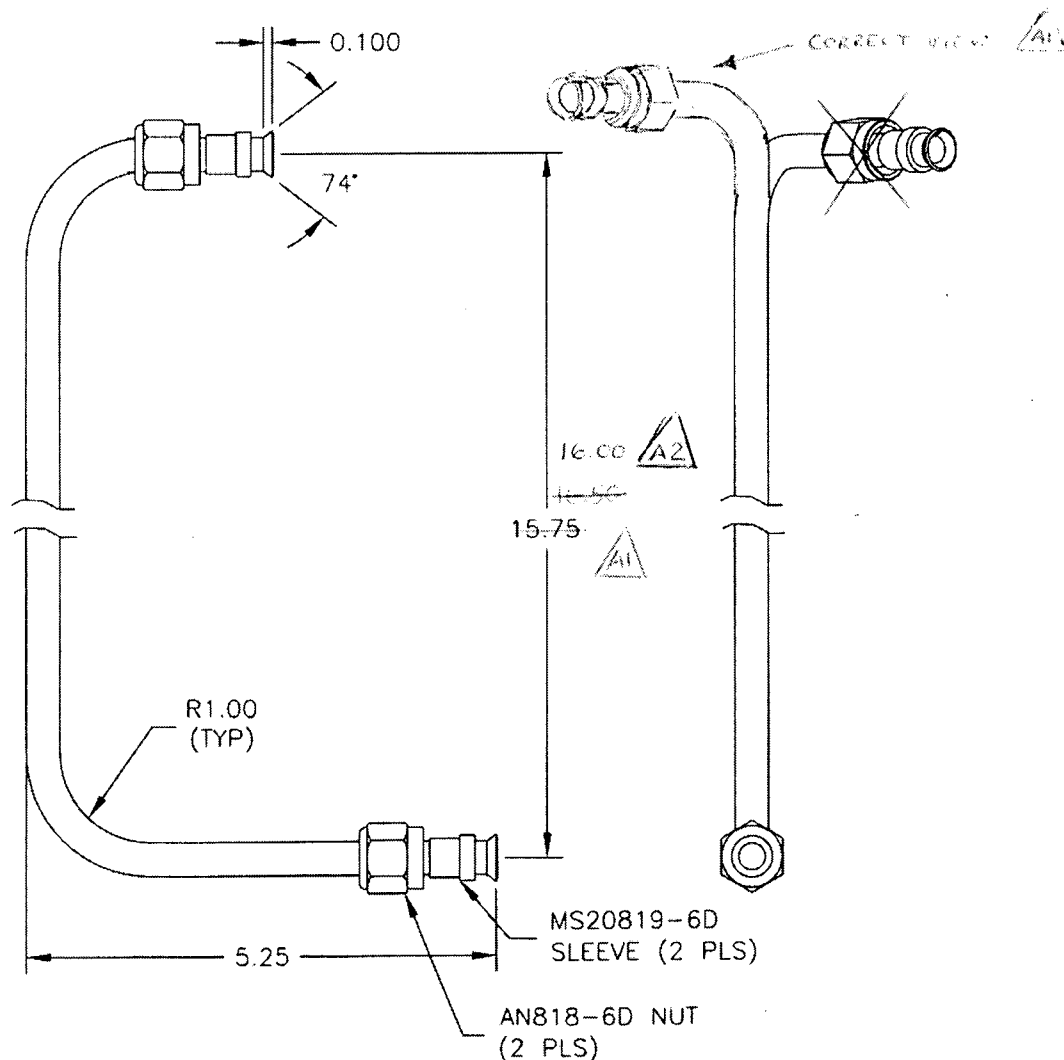


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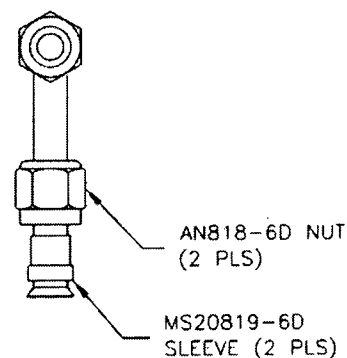
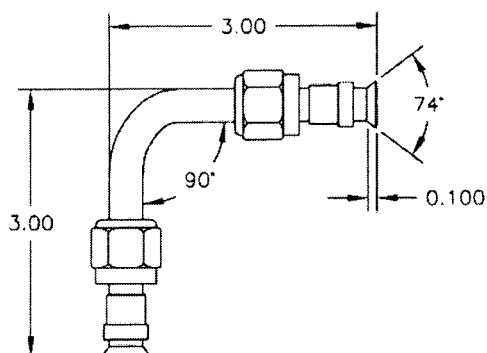
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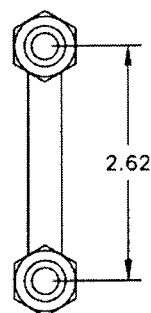
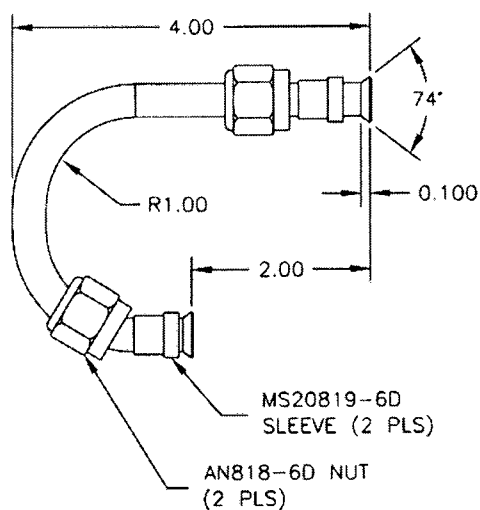


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04 07 06 H



**D3298-007**



**D3298-013**

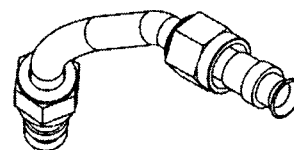
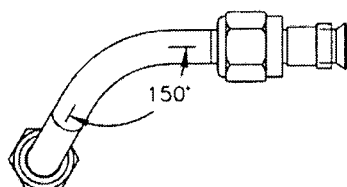
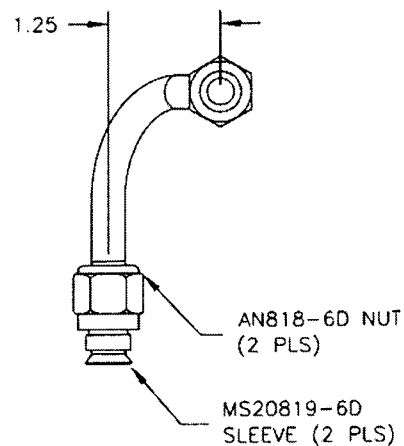
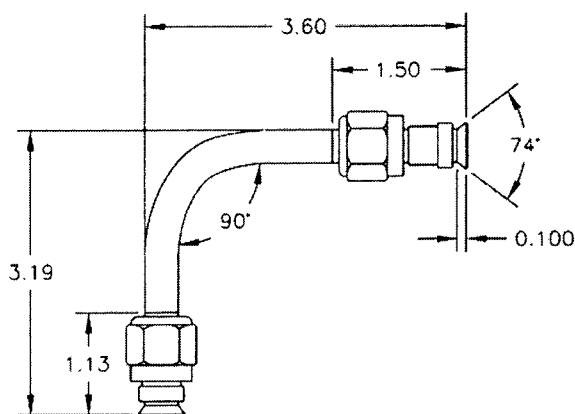
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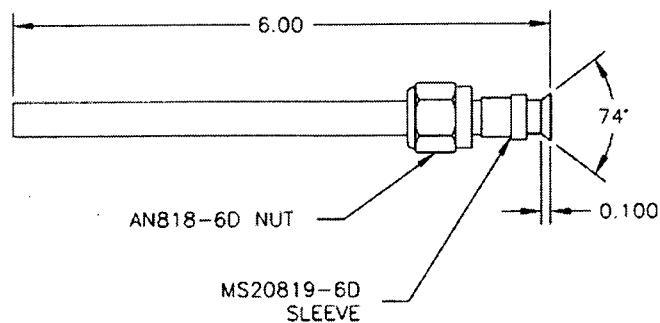


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**D3298-011**



**D3298-009**

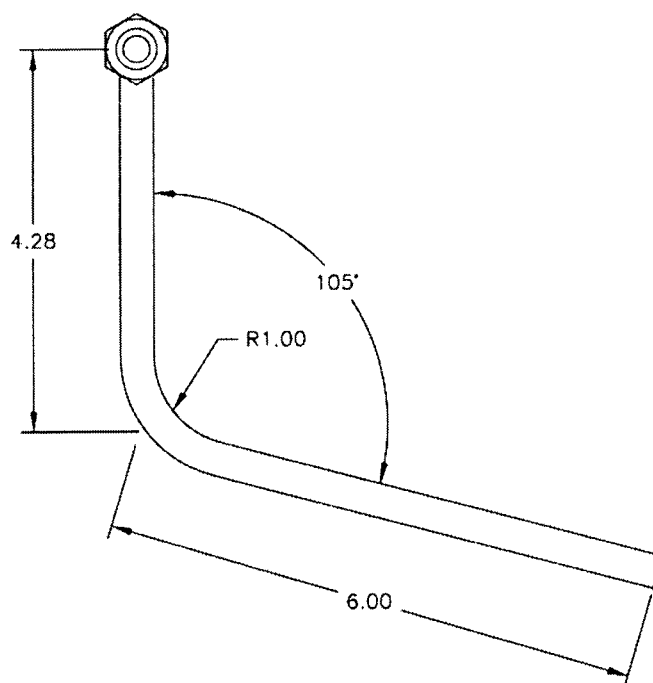
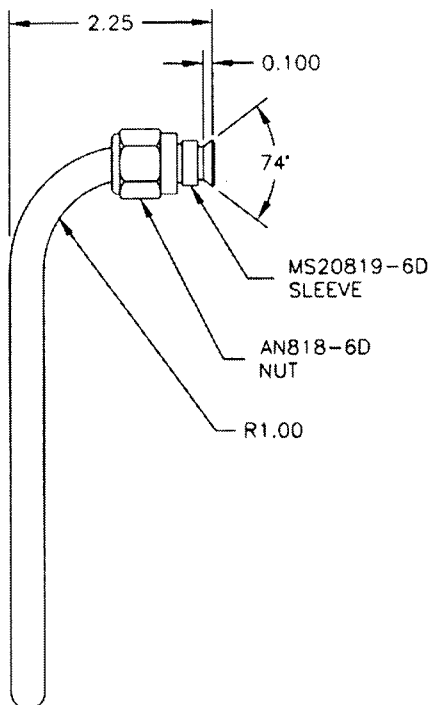
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